

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014083**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Strut connection U shape plate: - Caltrans QA Inspector observed a ZPMC welding operator performed SAW process on CJP weld of strut connection U shape plates. The material of strut connection U shape plate is ASTM 485 with 70mm wall thickness. The CJP weld and plate ID is SD1-SA4-56-123M-1-1B, SD1-SA4-56-123M-3-1B and SD1-SA4-56-123M-4-1B. The SAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Strut connection flat plate: - Caltrans QA Inspector observed two ZPMC welding operators performed SAW process on CJP weld of tower strut connection flat plate. The material used tower strut connection flat plate was reported by ZPMC QC as ASTM 345 with 28mm wall thickness and ASTM 485 with 60mm wall thickness. The CJP weld and plate ID are ED1-STSA4-6-127M-2-3B, WD1-STSA4-6-127M-2-3B and ND1-STSA4-6-127M-4-3B. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West tower lift #5:- Caltrans QA Inspector observed two welding operators performed SAW process on exterior corner longitudinal seam welds that connected skin plate A to B of west tower lift #5. The longitudinal seam weld number is #WSD1-TL5-4-B/F-20A/32A. The SAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

CLOSING STATEMENT

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

As notes within report above.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau, Wai	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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